Work Order ID 111326

111326

Reprint

May-14-14 10:40:16 AM

Item ID: D4635-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Aft Ceiling Panel, LH

Start Date: 1/13/14 **Start Qty:** 1.00 *1*

Required Date: 1/27/14 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** ML5 **Date:** 4-05-14 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4635 / Revision Nbr: E									DAS 07 9-89
100	HAND FINISHING THERMOFORMING	0.00				XL			
100		0.00							
Thermoform	**Memo**								
Thermoforming Machine	Cut Blanks								
105		0.00							DAS 07 9-89
105	Dry Material					XL			
HandThermo		0.00							
Hand Finishing Thermoforming	**Memo**								
	Dry Sheet as per QSI022 KYDEX								
	Temp: 245 deg. F	MAY 14 2014							
	Time IN: 5:00 PM								
	Time OUT: 6:00 AM	! Per.....							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 111326

111326

May-14-14 10:40:16 AM

Item ID: D4635-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Aft Ceiling Panel, LH

Start Date: 1/13/14 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 1/27/14 **Req'd Qty:** 1.00 *1* **Customer:**

Reference: **Run Start** *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	THERMOFORMING MACHINE	0.00				x1			DAS 07 9-89
110 Thermoform Thermoforming Machine	**Memo** Thermoform as per Dwg. D4635-3 and Folio FTA149	0.00							14/05/14
	Dwg. Rev. E								
	Folio Rev. D								
	Visually inspect for proper formation and texture								
130	HAND FINISHING THERMOFORMING	0.00				x1			14/05/15
130 Thermoform Thermoforming Machine	**Memo** Trim to Finished Dimensions	0.00							
140	QC2- Inspect parts off machine FAI/FAIB	0.00				(1)			SAD 14/05/20
140 QC Quality Control	**Memo**	0.00							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
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☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 111326

111326

May-14-14 10:40:16 AM

Item ID: D4635-3 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Aft Ceiling Panel, LH

Start Date: 1/13/14 **Start Qty:** 1.00 *1*

Required Date: 1/27/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150 QC Quality Control	Memo	0.00							
160	Packaging	0.00							
160 Packaging Packaging	Memo Section. MF	0.00				0		SAD 14/05/21	
170	QC21- Final Inspection - Work Order Release	0.00							
170 QC Quality Control	Memo	0.00						14/5/21 MF 14-5-21	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Centre Not Concentric
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☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
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☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
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☐ Misaligned/off center
☐ Mislabeled
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☐ Out of Calibration
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

May-14-14 10:40:21 AM

Work Order ID: 111326 *111326*

Parent Item: D4635-3 *D4635-3*

Parent Item Name: Aft Ceiling Panel, LH

Start Date: 1/13/14 **Required Date:** 1/27/14

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B
Dwg. Update 12/11/08 DL IPP Rev C Dwg. Ulpdate
13/07/09 DL IPP Rev. D Dwg. Update, Material
Change 13/12/18 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,688.773	9.39 **	10			DAS 07 9-89

MLEXS.093-F6006-07

GE PLASTICS LEXAN SHEET

14/05/14

Location	Loc Qty	Loc Code	
MAT023	1688.77332		
114459	229.26		
123105	38		
124501	543.5		
m128668	600.68		10 sq ft
m129014	277.33332		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

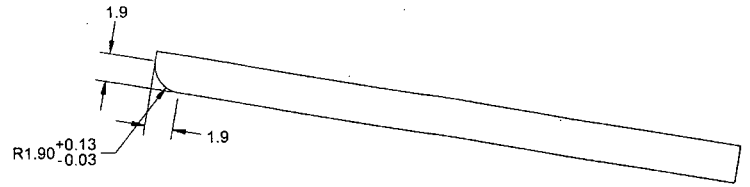
FAULT CATEGORY

Landing Gear

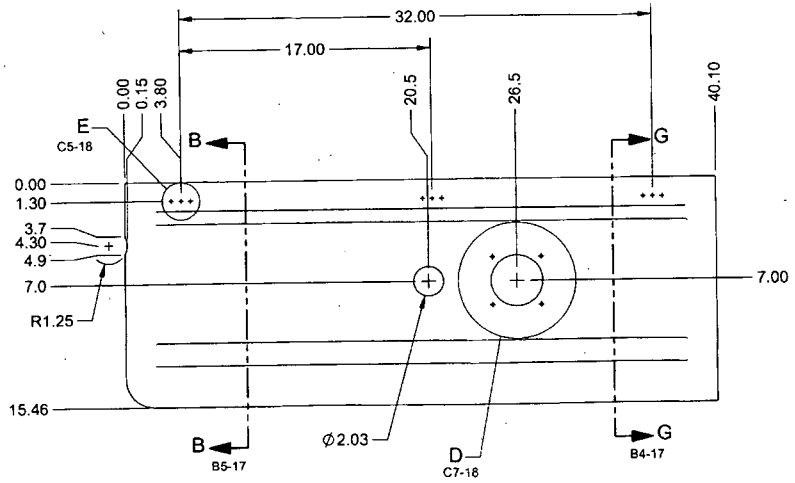
☐ Bending
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☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

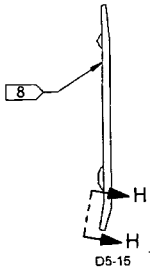
General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
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☐ Power Loss/Surge
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other



SECTION H-H B2-15





111326 MCJ
1405-14

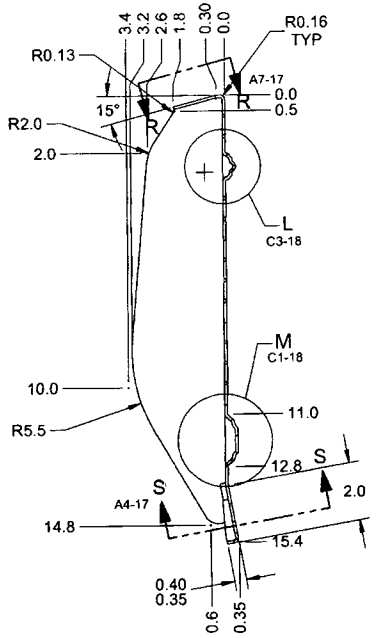
RELEASED
2014 -01- 22

NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS:093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.66 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-3 PER TOOL DT9841
10) THERMOFORM D4635-3 PER QSI 022 USING DT9849 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

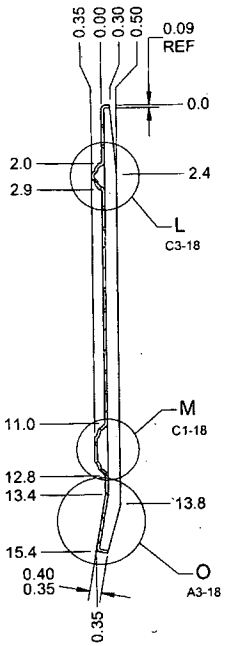
D4635-3 LH, AFT CEILING PANEL

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4635 REV. E
CHECKED	DC	SHEET 15 OF 18
MFG. APPR.		TITLE OUTBOARD CEILING PANELS
APPROVED		SCALE NTS
DE APPR.		
DATE	14.01.09	

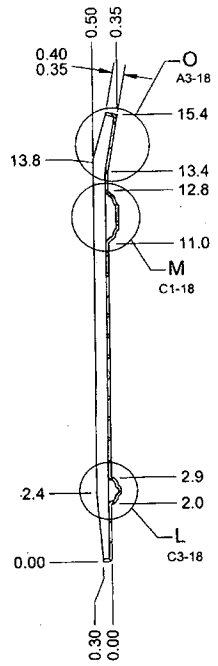
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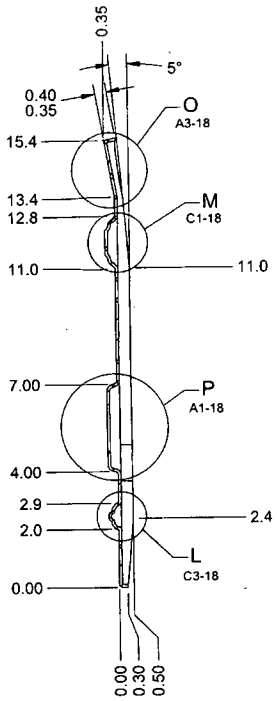
SECTION A-A
SECTION A'-A' OPPOSITE B3-13 B3-14
SCALE 2X



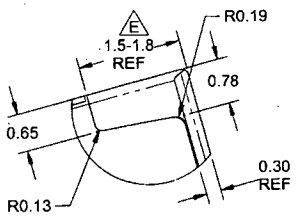
SECTION B-B B7-13 B7-14
SCALE 2X



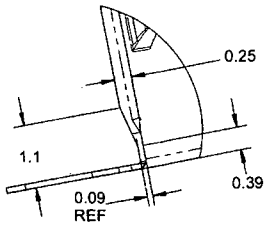
SECTION G-G B4-15 B4-16
SCALE 2X



SECTION K-K C6-16
SCALE 2X



AUXILIARY VIEW R-R
SECTION R'-R' OPPOSITE D7-17
SCALE 2X

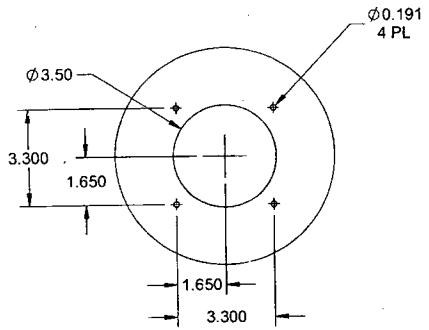


AUXILIARY VIEW S-S
SECTION S'-S' OPPOSITE B7-17
SCALE 2X

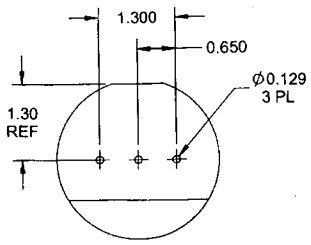
RELEASED
2014 -01- 22

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4635 REV. E
CHECKED	BC	SHEET 17 OF 18
MFG. APPR.		TITLE OUTBOARD CEILING PANELS SCALE NTS
APPROVED		
DE APPR.		
DATE	14.01.09	

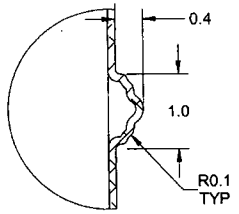
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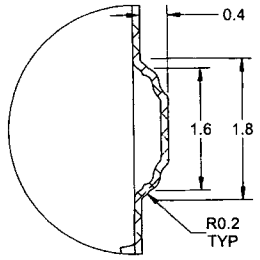
DETAIL D B4-13 B3-14 B5-15 B5-16
SCALE 2X



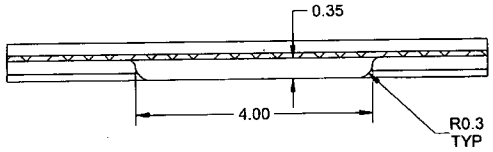
DETAIL E C7-13 B6-14 C6-15 B5-16
SCALE 4X



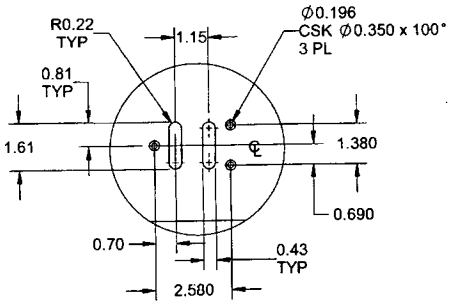
DETAIL L B2-17 B4-17 C5-17 C7-17
SCALE 1.5X



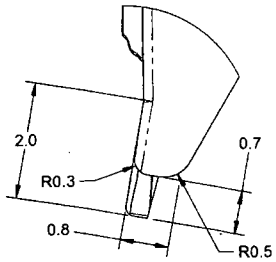
DETAIL M C2-17 C3-17 C5-17 C7-17
SCALE 1.5X



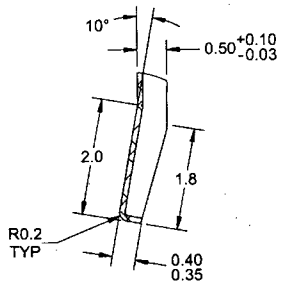
SECTION I-I B5-16
SCALE 4X



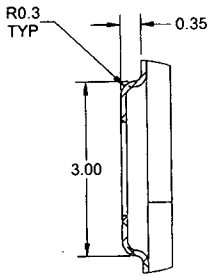
DETAIL Q C5-16
SCALE 2X



DETAIL N B2-13
SCALE 2X



DETAIL O D2-17 D3-17 B5-17
SCALE 2X



DETAIL P C2-17
SCALE 4X

RELEASED
2014-01-22

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. REV. E
CHECKED	BC	D4635 SHEET 18 OF 18
MFG. APPR.		TITLE SCALE
APPROVED		OUTBOARD CEILING PANELS NTS
DE APPR.		
DATE	14.01.09	

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DART AEROSPACE LTD

Description: Aft Ceiling Panel LH		**Work Order:** 111326
Inspection Drawing: 4635-3	**Rev:** E	**Part Number:** DX4635-3

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.80	+/- 0.030	3.83	✓		M-T	SFAB-21
17.00	+/- 0.030	17.00	✓		M-T	
32.00	+/- 0.030	32.00	✓		M-T	
20.5	+/- 0.100	20.5	✓		M-T	
26.5	+/- 0.100	26.5	✓		"	
7.0	+/- 0.100	7.0	✓		"	
7.00	+/- 0.030	7.00	✓		"	
Ø2,03	+0.012 -0.001	Ø2.04	✓		Vern	SFAB-08
3.300	+/- 0.010	3.300	✓			
1.650	+/- 0.010	1.650	✓			
3.300	+/- 0.010	3.300	✓			
1.650	+/- 0.010	1.650	✓			
Ø0.191	+0.005 -0.001	Ø0.191	✓			
1.300	+/- 0.010	1.300	✓			
0.650	+/- 0.010	0.650	✓			
Ø0.129	+0.005 -0.001	Ø0.129	✓		Vern	
Ø3.50	+0.012 -0.001	Ø3.54				

Measured by: SAJ	**Checked By:** SHJ	**QC inspector:** SHJ	**Engineering Approval** *(if necessary)*:
Date 14/05/20	**Date** 14/5/20	**Date** 14/5/20	**Date**